

Date: Tuesday, 26/06/2007 8:19:59 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 33139  
 Estimate Number : 12899

Drawing Name : BK117 SKIDTUBE ASSEMBLY

P.O. Number :  
 This Issue : 26/06/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : // Type : LANDING GEAR  
 Previous Run :

Part Number : D117762011

Drawing Number : N/A

Project Number : N/A

Revision : U/R

FOR ENGINEERING USE ONLY

At 08.07.10  
 IJN-0117-762 Rev A

Written By :  
 Checked & Approved By :  
 Comment : Est R

03/07/2007 Qty: 2 Um: Each

## Additional Product

Job Number:



Remove

D3512-1  
 B31199  
 (ATY 4)  
 2

14DD  
 D3512-1  
 B36180  
 (ATY 4)  
 2

00083

Seq. #: Machine Or Operat

1.0 DC



Comment: DOCUMENT CONTR  
 Photocopy bluefile

エアロファシリティ株式会社  
 Tel 03-5574-7655  
 FAX 03-5574-0111 CHG001



2.0 PACKAGING 1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

PACKAGING RESOURCE #1

Not req'd  
 at  
 07.07.02



3.0 D117762041



Replacement Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Replacement Skidtube B32910

4.0 D35121



WEARPLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 WEARPLATE B31199  
 Batch: B31199 B36180

07 06 26

5.0 AN960101 AN960101



Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)  
 Washer  
 Batch: M102473

07 06 26

Date: Tuesday, 26/06/2007 8:19:59 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 33139

Part Number: D117762011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3C4A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

BOLT

BATCH: M103641

*PA* 070626

7.0

AN451A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

BATCH: M103684

*PA* 070626

8.0

D2972

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

BATCH: B14103

*PA* 070626

9.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

BATCH: M100743

*PA* 070626

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

**ENGINEERING  
APPROVAL**  
*PA* 07-06-29

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-751-011

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

NOT REQ'D *PA* 07-07-02  
**FOR ENGINEERING USE ONLY**

①

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*PA* 070709  
*U* 07-07-09

Job Completion



**DART**

DART AEROSPACE USA, INC.  
110 Chimacum Creek Drive  
Port Hadlock, WA 98339

Tel: 1 613 632 5200

Fax: 1 613 632 5246

e-mail: [heli@dartaero.com](mailto:heli@dartaero.com)

<http://www.dartaero.com>

## INSTALLATION INSTRUCTIONS

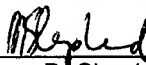
IIN-D117-762

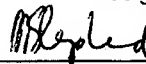
### *Skidtube Installations*

EUROCOPTER BK 117 A-1/A-3/A-4/B-1/B-2/C-1 MODELS

33139  
PT  
03.07.10

Prepared By:   
P. Hum  
Mechanical Designer

Checked By:   
D. Shepherd, P. Eng  
Design Engineer

Released By:   
D. Shepherd, P. Eng  
Design Engineer

• COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: **A**

Date: 07.04.27

## 5.0 PARTS LIST

## 5.1 D117-762-011 Skidtube Parts List

Item	Qty -011	Qty -041	Part Number	Description
	X		D117-762-011	SKIDTUBE INSTALLATION
	1	X	D117-762-041	REPLACEMENT SKIDTUBE
1		1	D3582-041	SKIDTUBE ASSEMBLY
2	2		**1121-51002	SKID SHOE
3	2		**1121-51102	CLAMPING RING
4	8		**LN9380M8X45	HEXAGON BOLT
5	8		**LN9023A8-1.4544.9	LOCKING WASHER
6	8		**LN9025-0815K	WASHER (OR LN9025-0815L)
10		1	*D2965	CAP
11		2	***AELS-1032-225	INSERT
12		2	*AN3C5A	BOLT
13		2	*AN960C10L	WASHER
20A		1	*D3508-9	WEARPLATE
20B		1	*D3558-9	GASKET
21A		1	*D3508-3	WEARPLATE
21B		1	*D3558-3	GASKET
22A		1	*D3508-11	WEARPLATE
22B		1	*D3558-11	GASKET
23A		1	*D3508-13	WEARPLATE
23B		1	*D3558-13	GASKET
24		36	*AELS-1032-130	INSERT
25	8	28	*AN3C4A	BOLT
26	8	28	*AN960C10L	WASHER
27	2		D3512-1	WEARPLATE
30		2	*AELS-1032-130	INSERT
31		2	*AN4-4A	BOLT
32		2	*AN960JD416L	WASHER
40		2	*D3492-049	PLUG ASSEMBLY
41		2	***NAS1611-016	O-RING
42		2	*D3492-051	PLUG ASSEMBLY
43		2	***NAS1611-015	O-RING
44		6	*D3492-053	PLUG ASSEMBLY
45		6	***NAS1611-012	O-RING
50	2		AN4-51A	BOLT
51	4		D2972	BUSHING
52	2		MS21042L4	NUT (OR MS21042-4)

\* PART IS INCLUDED WITH D3582-041 SKIDTUBE ASSEMBLY  
 \*\* TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY  
 \*\*\* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

• COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. •  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: A

Date: 07.04.27

33139  
 PH 06.07.10